

Work Order ID 132155-1

April-29-15 9:20:25 AM

SPRIT *132155*

Page 1

Item ID: 650.0401

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: PUREair Fairing Assembly

Start Date: 4/29/15 Start Qty: 35.00

35

30

Cust Item ID:

Required Date: 4/29/15 Req'd Qty: 35.00

35

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

105

0.00

DAS

07

9-89

105

Thermoform

Thermoforming Machine

Memo

0.00

PULL FROM STOCK:

4 X 650.0401 B130374 - x7
8 X 650.0401 B130604 - x8
6 X 650.0401 B130895 - x5
4 X 650.0401 M121173 - x5
3 X 650.0401 M129351 - x3
5 X 650.0401 M129465 - x5
5 X 650.0401 M129683 - x5
1 X 650.0401 M130067 x1

REMOVE ALL NUTPLATES FROM FAIRINGS, PER CLICK BOND
PROCESS SPECIFICATION CBPS-207

ADD NEW NUTPLATES PER ECN

x38

x1

15/05/20

P10 →
LAST PAGE

107. spray paint per drawing - UNF 15-6-23

PER Q52005

DAS

41

9-89

15-7-2

Picklist Print

April-29-15 9:20:22 AM

Page 1

Work Order ID: 132155

132155

Parent Item: 650.0401

650 0401

Parent Item Name: PUREair Fairing Assembly

Start Date: 4/29/15

Required Date: 4/29/15

Start Qty: 35.00

Required Qty: 35.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
650.0401		Purchased		No			Each	0.0000		35			
650 0401									**				
PUREair Fairing Assembly													

~~LN9038-0516 x 70 B:~~

CB6014CR5M-1P x 490 B: $\frac{132399}{B132569} \times 500.$

OK 15/06/12.

~~LN9038-0514 x 420 B:~~

~~NAS1149D0332P x 490 B:~~

List Lots

April-29-15 9:13:57 AM

Page 1 of 1

Criteria : Item ID: 650.0401 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
650.0401 PUREair Fairing Assembly	Main Warehouse cck024	130374 ✓ x4	4/28/15	4.0000	-4 cck33		
	Main Warehouse cck024	130604 ✓	12/13/14	8.0000	-4 done. +4		
	Main Warehouse cck024	130895 x3 -	12/13/14	6.0000	-3 cck24		
	Main Warehouse Mezz2	m121173 ✓	12/14/14	4.0000	Box 1 x4		
	Main Warehouse Mezz2	m129351 ✓	12/14/14	3.0000	- box 2		-1
	Main Warehouse Mezz2	m129465 ✓	12/14/14	5.0000	- box 2		
	Main Warehouse Mezz2	m129683 ✓	12/14/14	5.0000	box 1 x5		

Total: 35.0000

38.000 cck51 x2 ?8

Box 3 = 6
Box 2 = 8
Box 1 = 9
STORES = 7
THERM.FG107 = 8

Linda Lacelle

From: Harvey Siemens
Sent: April-29-15 9:12 AM
To: Linda Lacelle
Subject: RE: d350-822

Linda,

That's a BIG 10-4.

There are no good to us the way they are.

y
HS

From: Linda Lacelle
Sent: April-29-15 6:53 AM
To: Harvey Siemens
Subject: d350-822

Hi Harvey, do we go ahead with removing all the nutplates on the fairings??

I

CLICK BOND

2151 Lockheed Way • Carson City, Nevada 89706

PROCESS SPECIFICATION CBPS-207

REVISION A SEPTEMBER 23, 1993
REVISION B OCTOBER 5, 2000

PROCEDURE TO REMOVE CLICK BOND FASTENERS

PAGE	1	2	3	4	5	6	7	8	AMENDMENT 1
REVISION	A	A	A	B	A	A	A	A	20MAR95

PROCESS SPECIFICATION CBPS-207

REVISION A SEPT 21, 1993

PROCEDURE TO REMOVE CLICK BOND FASTENERS

1. SCOPE

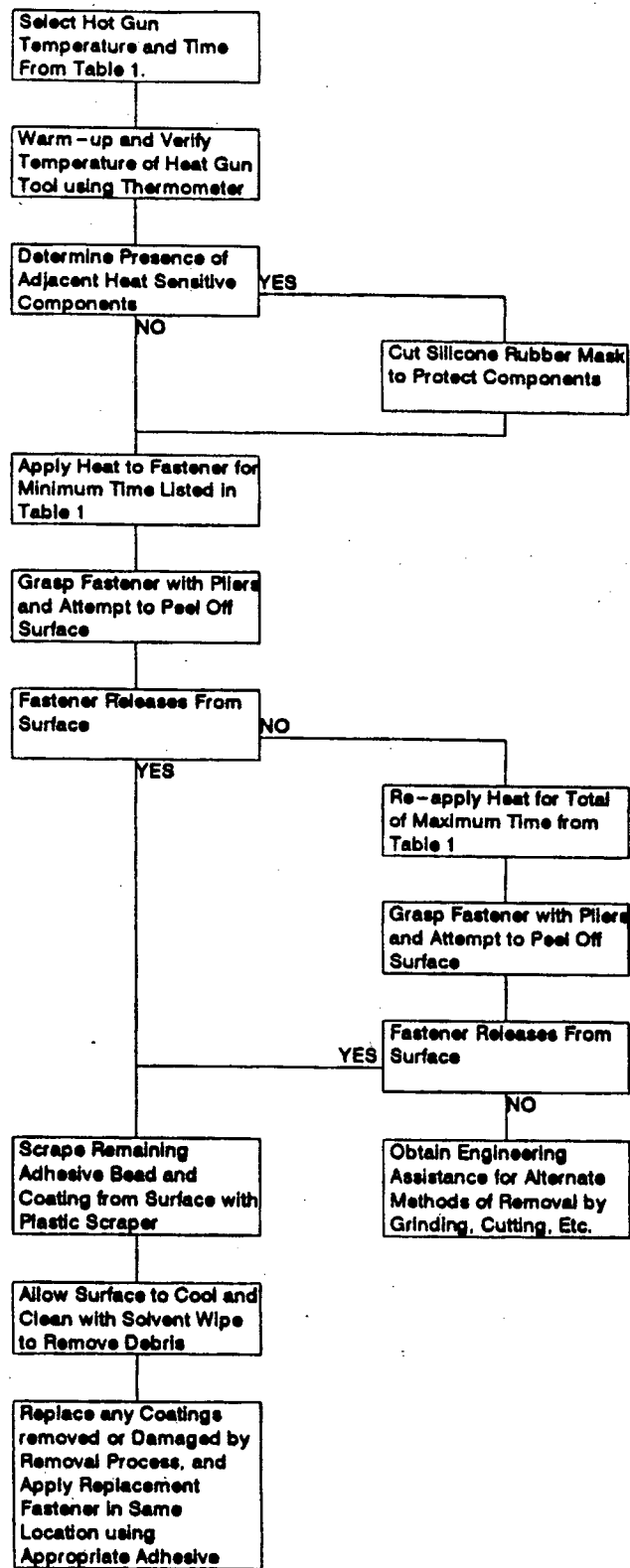
- 1.1 This process specification establishes procedures for removing various Click Bond adhesive bonded fasteners which are mounted to composite or metallic substrates.

2. REQUIREMENTS

2.1 MATERIALS

2.1.1 EQUIPMENT & SUPPLIES

- 2.1.1.1 Portable temperature controlled heat gun, Click Bond CB 115 or equal.
- 2.1.1.2 Scraper, plastic blade, Click Bond CB 116 or equal
- 2.1.1.3 Pliers, slip joint, commercial
- 2.1.1.4 Thermometer 0 to 500 F, commercial
- 2.1.1.5 Silicone rubber sheet, 1/8 inch thick, commercial





2151 Lockheed Way • Carson City, Nevada 89706

PROCESS SPECIFICATION CBPS-207

REVISION A SEPT 21, 1993

- 2.3 Selection of temperature and heat application time.
 - 2.3.1 All substrate materials must be protected from excessive temperatures during the application of heat to soften the adhesive material attaching the fastener. Excessive temperatures can cause the following damage, some of which will not be apparent to the mechanic but which can materially affect the function of the structure.
 - 2.3.2 Damage caused by over temperature:
 - 1. Loss of temper and strength in metallic substrates
 - 2. Disbonds and delamination in composite substrates
 - 3. Blistering and loss of bond strength of protective coatings
 - 4. Failure of adjacent temperature sensitive components
 - 2.3.3 Limitation of over temperature damage. Simple ways to prevent over temperature damage are:
 - 1. Keep maximum output air temperature of heat gun below the threshold of damage temperature of the substrate and adjacent components
 - 2. For output air temperatures above this threshold temperature, limit the time of heat application such that adjacent components and substrate do not reach the threshold temperature. This time will be a function of the thermal mass of the component and substrate.
 - 3. Mask adjacent components and exposed substrates with a thermal barrier to keep heat transfer to a minimum and delay temperature rise in protected components.
 - 4. Use recommended settings from Table 1 and monitor substrate and adjacent component temperatures with a thermocouple or temperature indicating paint.

2.3.4 USE OF TABLE #1

Choose appropriate row which describes adhesive type used for fastener bonding.

Choose appropriate row which describes substrate material.

TABLE 1
HEAT GUN TEMPERATURE AND DWELL TIMES
FOR CLICK BOND FASTENER REMOVAL

ADHESIVE	SUBSTRATE	HEAT GUN		DWELL TIME SECONDS	
		SETTING #	TEMP °C	MIN.	MAX.
CB200	METAL	3	265	30	45
	COMPOSITE	2	180		
CB316	METAL	3	265	30	45
	COMPOSITE	2	180		
CB359	METAL	3	265	30	60
	COMPOSITE	2	180		
CB394	METAL	3	265	45	55
	COMPOSITE	3	265		

The appropriate column will give a tool setting, a recommended heat gun air temperature, and a suggested minimum and maximum dwell time.

PROCESS SPECIFICATION CBPS-207

REVISION A SEPT 21, 1993

2.3.5 Masking of adjacent heat sensitive components.

When applying heat in areas with a high density of heat sensitive components, a conformal mask cut from silicone rubber sheet can be draped over the parts with a hole cut into it to expose the fastener to be removed. The hot air stream from the heat gun is concentrated on the area of the hole and the adjacent areas are shielded from the heat. A typical mask is shown in Figure 1.

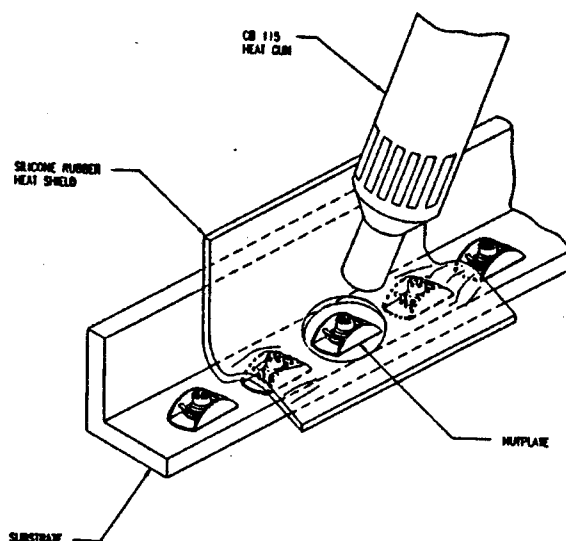


Figure 1.

2.4 Applying heat

Hold the hot gun tool so that the air stream impinges upon the fastener as near to a right angle to the plane of the substrate as possible. This will cause the fastest heating of the fastener and minimize heat transfer to the substrate. Position the tip of the tool approximately one inch from the baseplate of the fastener. Keep air stream centered on fastener. See Figure 2.



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REVISION A SEPT 21, 1993

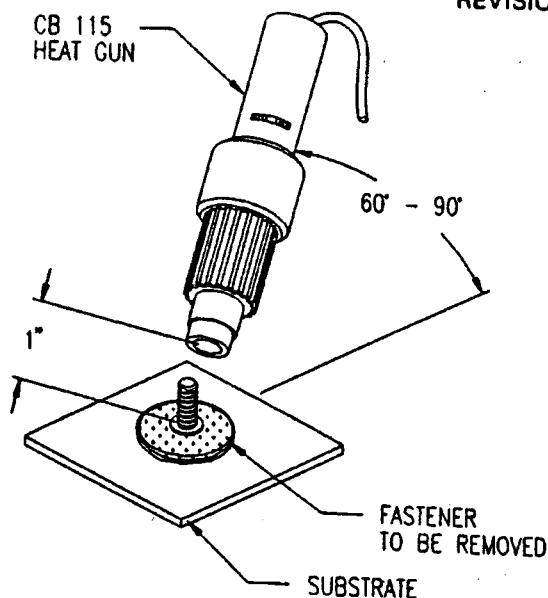


Figure 2.

2.4 Removing Fastener

After the correct elapsed time, turn off heat gun and set aside. Using pliers, promptly grasp fastener and tip off surface using an application of force which maximizes cleavage or peel stress on the bondline. See Figure 3.

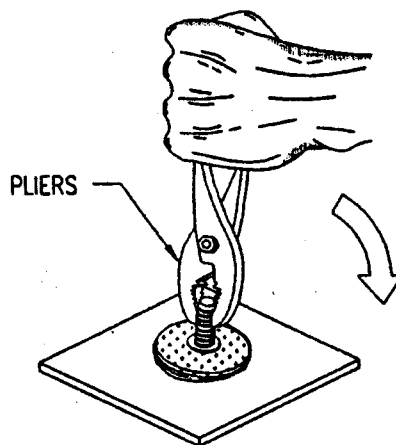


Figure 3.

2.5 Removing Residual Adhesive

The adhesive remnants which remain behind on the substrate surface should be removed by again applying heat from the hot gun to the surface for a short time and then scraping the softened material from the surface with a chisel blade or scraper. Care should be used to avoid scratching the surface or causing delamination of substrate materials around holes and edges. See Figure 4.

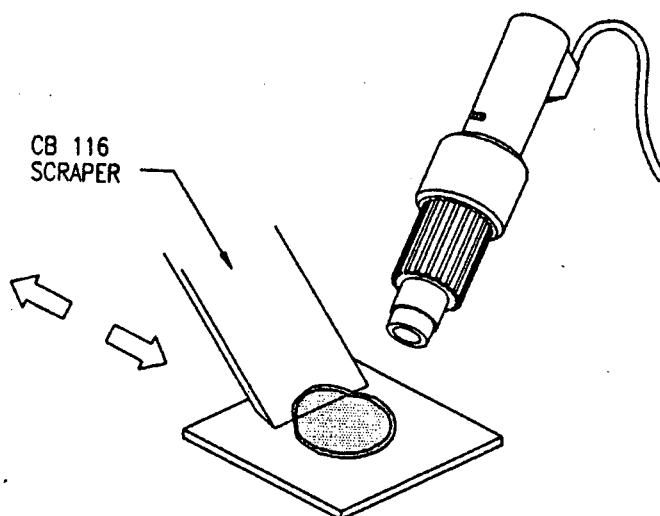


Figure 4.

Allow the substrate to cool to room temperature and then lightly sandpaper surface with 200 grit paper to prepare for re-bonding or protective coating application. Wipe with solvent and dry.

PROCESS SPECIFICATION CBPS-207

REVISION A SEPT 21, 1993

- 3.0 Safety and Environmental Compliance
- 3.1 Those persons using electric powered tools to apply heat to aircraft components must consider the flammable or explosive nature of certain aircraft structures. The wings and fuselage frequently contain fuel tanks which could present a fire or explosion hazard. Fuel tanks must be properly inerted by qualified technicians prior to being worked on.
- 3.2 Proper ventilation is necessary to prevent the accumulation of fuel vapor in low spots of structures and possible ignition by sparks from tools used to cut, drill or heat components. Ventilation is also necessary to allow persons to enter these structures and work. A supplemental supply of breathing air for the worker and a person standing safety watch outside the structure is sometimes necessary.
- 3.3 Solvents used for cleaning surfaces must be used sparingly and proper ventilation provided to protect the worker from inhalation of the fumes.
- 3.4 Airborne particulate matter provided by sanding, drilling and cutting should be removed by local suction from an appropriate source.
- 3.5 The storage, handling, use, transportation and disposal of goods, supplies, materials, articles, items, equipment, machines, tools, parts, components, assemblies, chemicals and processes referenced herein shall comply with all applicable national/international, federal, state and local health, safety and environmental laws, ordinances, rules, regulations and codes.



**CBPS-207 Revision A
AMENDMENT 1 - MARCH 20, 1995**

**PROCEDURE TO REMOVE CLICK BOND FASTENERS
SEALED NUTPLATES AND SLEEVED SEALED NUTPLATES**

SLEEVED SEALED NUTPLATES

When it becomes necessary to remove a sleeved sealed nutplate (because of nut failure, leakage, or other requirements), the first step in the procedure is to drill out the sleeve. Care should be exercised to avoid damaging the substrate. It will be necessary in most instances to use the same hole for installation of another sleeved nutplate after this fastener has been removed. In these instances, it will be helpful for the substrate hole to have the same diameter as was used for the initial fastener installation.

After the sleeve has been removed, the procedure specified in CBPS-207 for fastener removal should be followed.

CAUTION: PLEASE FOLLOW ALL SAFETY PRECAUTIONS FOR THE FASTENER REMOVAL PROCEDURE. PARTICULAR ATTENTION SHOULD BE GIVEN TO PARAGRAPHS 3.1 AND 3.2 ON PAGE 8 OF 8.

EXAMPLES OF SLEEVED SEALED NUTPLATES: CB2110, CB3110, CB9069

SEALED NUTPLATES

When it becomes necessary to remove a sealed nutplate (because of nut failure, leakage, or other requirements), follow the CBPS-207 procedure for fastener removal.

CAUTION: PLEASE FOLLOW ALL SAFETY PRECAUTIONS FOR THE FASTENER REMOVAL PROCEDURE. PARTICULAR ATTENTION SHOULD BE GIVEN TO PARAGRAPHS 3.1 AND 3.2 ON PAGE 8 OF 8.

EXAMPLES OF SEALED NUTPLATES: CB2010, CB2016, CB2031
CB3010, CB3016, CB9004, CB9030

NOTE: In the case of a sealed nutplate in which leakage is a concern, a sealant may be used to rectify the problem.

650.0401 PUREair Fairing Assembly

Batch	Quantity	Location	Status	Colour
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
130604	1	Over Quarantine Area	Nutplates Removed	Dark Green
TOTAL	8			
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
130374	1	Over Quarantine Area	Nutplates Removed	Dark Green
TOTAL	7			
130895	1	Over Quarantine Area	Nutplates Removed	Dark Green
130895	1	Over Quarantine Area	Nutplates Removed	Dark Green
130895	1	Over Quarantine Area	Nutplates Removed	Dark Green
130895	1	Over Quarantine Area	Nutplates Removed	Dark Green
130895	1	Over Quarantine Area	Nutplates Removed	Dark Green
TOTAL	5			
121173	1	Over Quarantine Area	Nutplates Removed	Light Green
121173	1	Over Quarantine Area	Nutplates Removed	Light Green
121173	1	Over Quarantine Area	Nutplates Removed	Light Green
121173	1	Over Quarantine Area	Nutplates Removed	Light Green
121173	1	Over Quarantine Area	Nutplates Removed	Light Green
TOTAL	5			
129351	1	Over Quarantine Area	Nutplates Removed	Light Green
129351	1	Over Quarantine Area	Nutplates Removed	Light Green
129351	1	Over Quarantine Area	Nutplates Removed	Light Green
TOTAL	3			
129465	1	Over Quarantine Area	Nutplates Removed	Light Green
129465	1	Over Quarantine Area	Nutplates Removed	Light Green
129465	1	Over Quarantine Area	Nutplates Removed	Light Green
129465	1	Over Quarantine Area	Nutplates Removed	Light Green
129465	1	Over Quarantine Area	Nutplates Removed	Light Green
TOTAL	5			
129683	1	Over Quarantine Area	Nutplates Removed	Light Green
129683	1	Over Quarantine Area	Nutplates Removed	Light Green
129683	1	Over Quarantine Area	Nutplates Removed	Light Green
129683	1	Over Quarantine Area	Nutplates Removed	Light Green
129683	1	Over Quarantine Area	Nutplates Removed	Light Green
TOTAL	5			
Total Actual	38			



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.		04939		SHEET 1 OF 1	
DWG NO.	650.0400	REV:	C	PREPARED BY	J. SOTO
DATE:		04/28/2015			
EFFECT ON DWG ☒ INC. ☐ UNINC.					
DWG TITLE: AS350 EAPS FAIRING ASSY					
APPROVED BY:	ENGR <i>[Signature]</i>	MFG	<i>[Signature]</i>	QC	<i>[Signature]</i>
EFF. NEXT ORDER					
REASON: REVISED F/N 4, 5, 6, & 9 FROM IMPERIAL TO METRIC.					
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE					

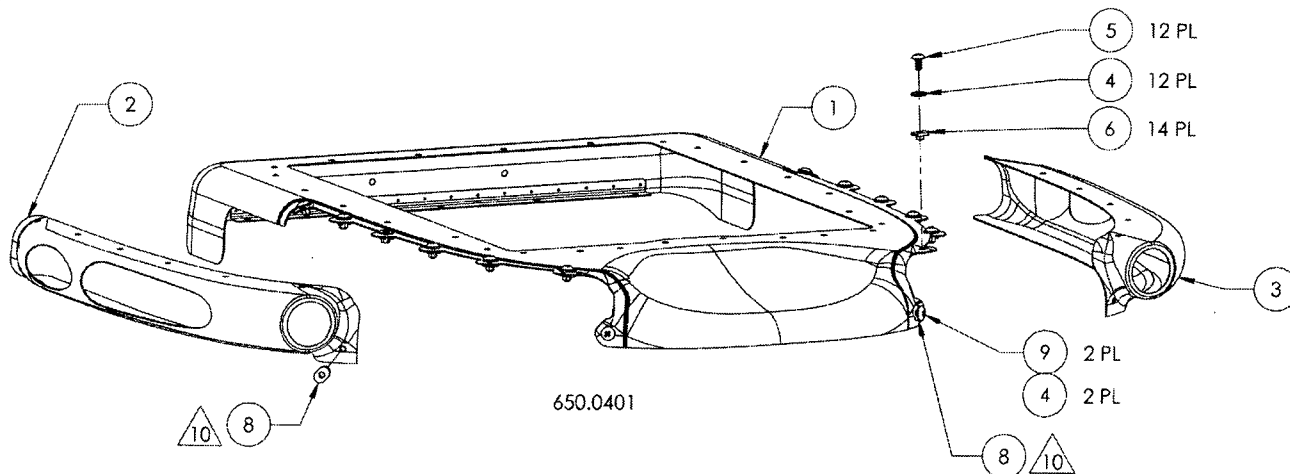
9	R	601.3803	2	SCREW	LN9038-05-16	
6	R	601.3802	14	CLICK BOND, NUTPLATE	CB6014CR5M-1P	
5	R	601.3801	12	SCREW	LN9038-05-14	
4	R	601.3800	14	WASHER	BS4320-A5	NAS1149 D0332 J
F/N	TC	PART NUMBER	.0401			
		QTY		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY		
☐ PATTERN ☐ MDL ☒ INSTALL INSTRUCTIONS ☒ ICA ☐ FMS ☒ BOM				☐ MAJOR ☒ MINOR		
				DER REVIEW REQUIRED		
				☐ YES ☒ NO		

1 2 3 4 5 6 7 8

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NOTES:

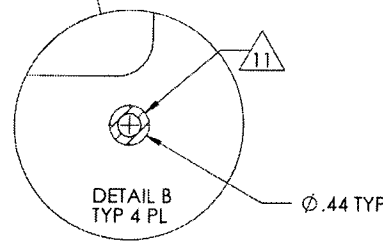
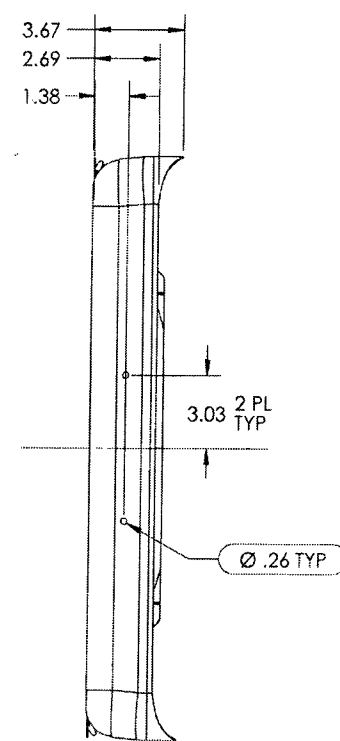
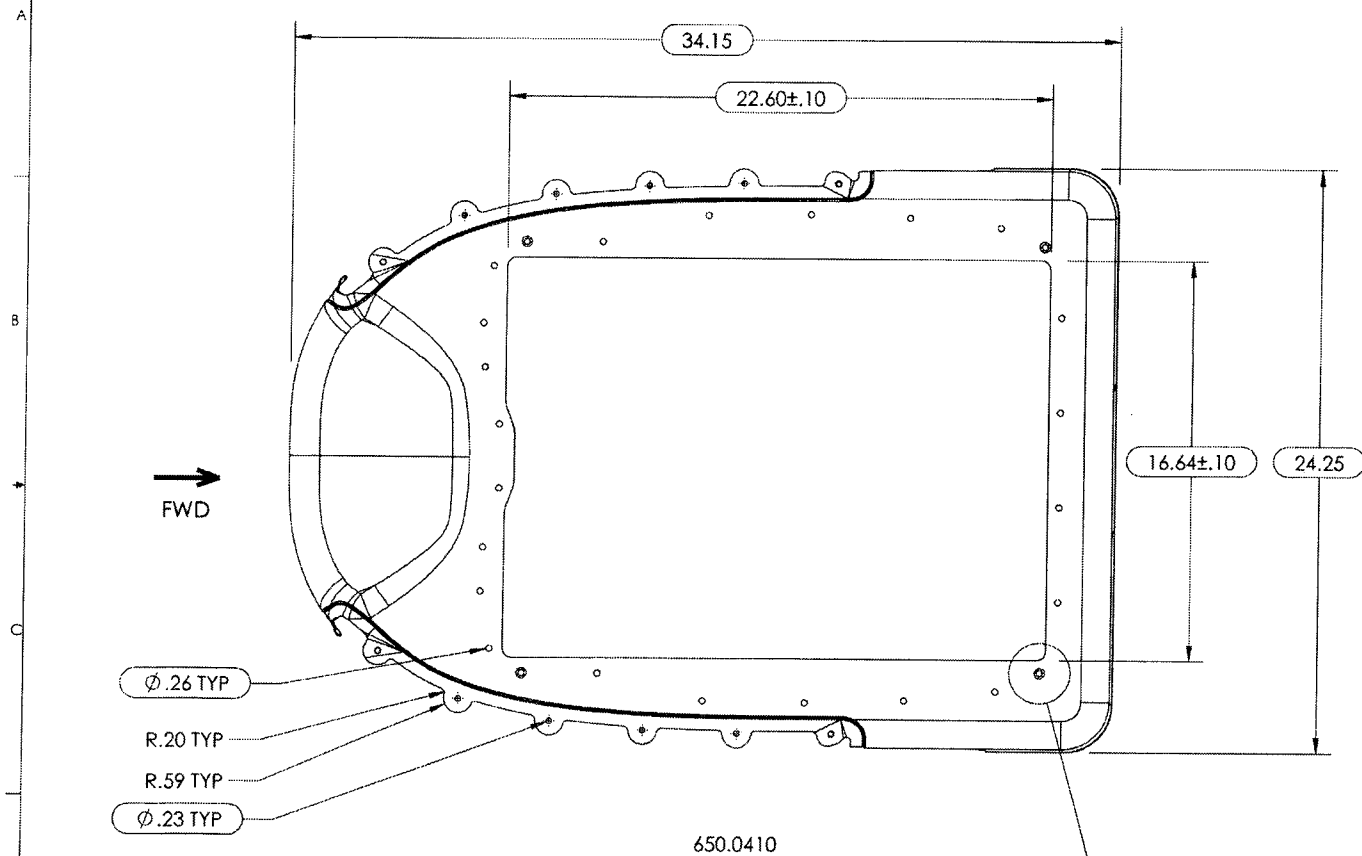
1. IDENTIFY IAW MPP 120
2. MANUFACTURE IAW MPP 145
3. PART DIMENSIONS CONTROLLED BY 3D CAD MODEL
F/N 1 CONTROLLED BY "650.0410 FAIRING.SLDPRT", LAST MODIFIED: 7/24/13
F/N 2 CONTROLLED BY "650.0411 RIGHT EJECTOR COVER.SLDPRT", LAST MODIFIED: 7/24/13
F/N 3 CONTROLLED BY "650.0412 LEFT EJECTOR COVER.SLDPRT", LAST MODIFIED: 7/17/13
4. MATERIAL: GREY EPOXY SURFACE VEIL (AX-2140-50")
5. MATERIAL: COPPER LIGHTNING STRIKE PROTECTION 3CU-125A (05-02632)
6. MATERIAL: CARBON FIBER PREPREG
CARBON FIBER: ALDILA PREPREG SYSTEM 3K 2X2-FR250B-204/40-50"
7. CURE TEMPERATURE: 260°F FOR 4 HOURS, SEE DRAWING DETAILS ON SHEET 3 FOR LAYUP SCHEDULE
8. PRIME IAW MIL-PRF-85582, 5 MIL MAX, MASK NUTPLATE THREADS
9. MATERIAL: POLYCARBONATE
10. ATTACH F/N 8 TO F/N 2 OR 3 USING PLASTIC WELDER FROM VENDOR DEVCON
11. APPLY MASKING PRIOR TO PRIMING



REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE	07/25/13	J. CARPENTER
2	INCORPORATED ECH 04015	11/27/13	P. BRAVO
3	INCORPORATED ECH 04015	12/17/13	P. BRAVO
4	INCORPORATED ECH 04015	04/18/14	P. BRAVO
5	INCORPORATED ECH 04015	04/28/15	P. BRAVO

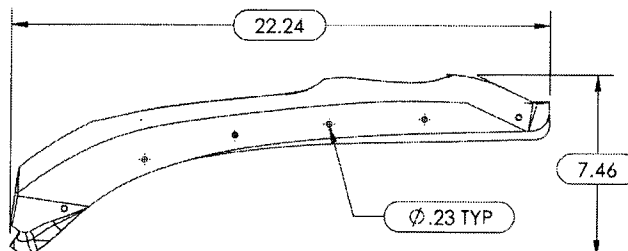
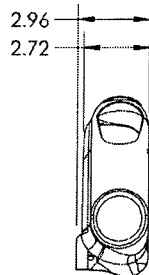
QTY	F/N	P/N	DESCRIPTION	MATL	SPEC.
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2	8	650.0415	SPACER		
14	6	601.3802	CLICK BOND, NUTPLATE	CB6014CR5M-1P	
12	5	601.3801	SCREW	LN9038-05-14	
14	4	601.3800	WASHER	BS4320-A5	
1	3	650.0412	LEFT EJECTOR COVER		
1	2	650.0411	RIGHT EJECTOR COVER		
1	1	650.0410	FAIRING		
1	1	650.0401	AS350 EAPS FAIRING ASSY		
PARTS LIST					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760) 724-5300					
AS350 EAPS FAIRING ASSY					
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES					
TOLERANCES ARE:					
2 PLACE DECIMALS ±.03					
3 PLACE DECIMALS ±.010					
ANGLES ±.5°					
REV	DATE	BY	CHKD	NO.	REV
B	07/16/13	J. CARPENTER			D
SCALE: NONE					
SHEET 1 OF 4					

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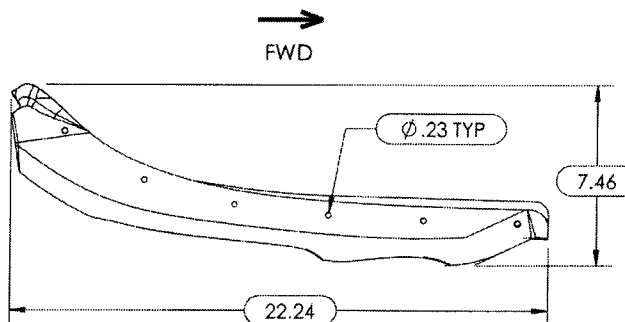
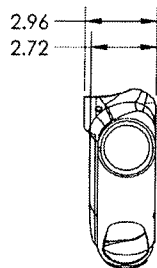


ORIGINAL DATE 07/16/13		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
CHECKED BY J. GARDNER		AS350 EAPS FAIRING ASSY	
DRAWING APPROVAL J. GARDNER		650.0400	
CONTRACT NO.		SCALE NONE	SHEET 2 OF 4
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SHEET 2 OF 4	REV D

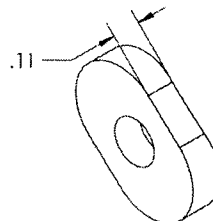
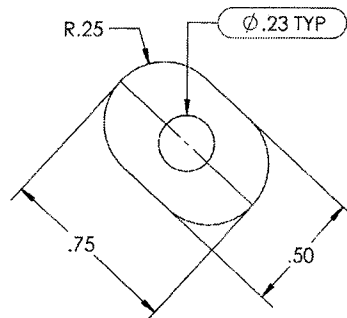
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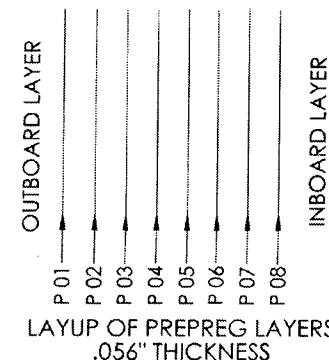
650.0411



650.0412



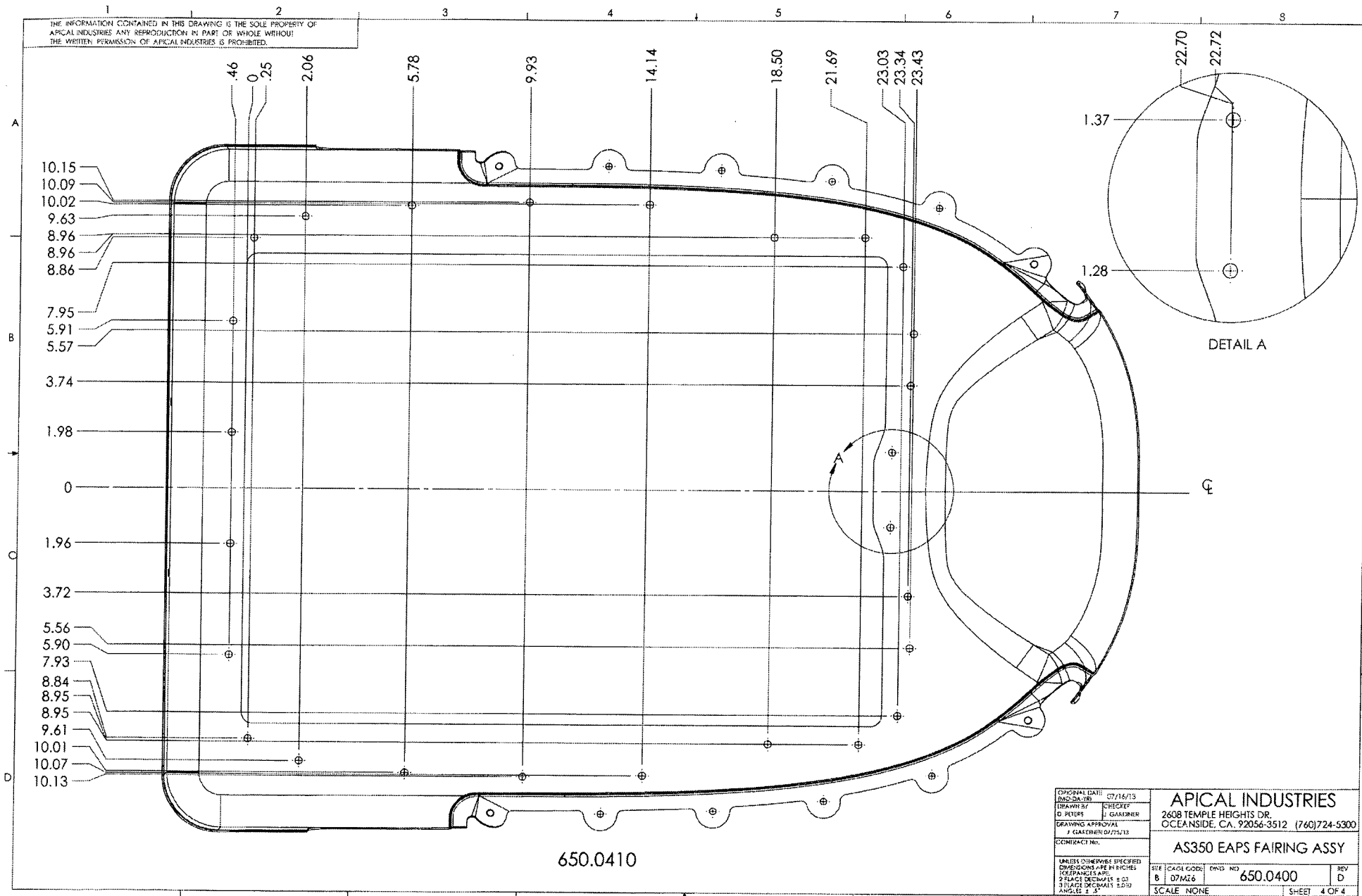
650.0415



LAMINATE 1 - .056" (6 LAYERS CARBON FIBER)			
PLY	WARP ANGLE	MATERIAL	THICKNESS
01	NA	△	.004"
02	NA	△	.004"-.012"
03	0	△	.008"-.010" PER LAYER
04	90	△	
05	0	△	
06	90	△	
07	0	△	
08	90	△	

(ORIGINAL DATE) (DATE) 07/16/13 DRAWN BY: J. CLARKE D. PETERS DRAWING APPROVAL: J. CLARKE (CONTRACT) NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES (TOLERANCES ARE) 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 07M26 SCALE NONE	QWS NO 650.0400 REV. D SHEET 3 OF 4

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ORIGINAL DATE: 07/16/13		APICAL INDUSTRIES	
DRAWN BY: J. CLARK		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. CLARK		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: J. CLARK 04/25/13		AS350 EAPS FAIRING ASSY	
CONTRACT NO.		8 07ME6 650.0400	
MULTIPLE DIMENSIONS SPECIFIED		SCALE: NONE	SHEET: 4 OF 4
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
2 PLACE DECIMALS ± .03			
3 PLACE DECIMALS ± .010			
ANGLES ± .5°			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *AW*

Date: 15/11/23

QA Closed: *AW*

Date: 15/11/18

Work Order: <u>132155</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>6500401</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>15-5443</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☒			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY														
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☒ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge			☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		